

**Work Order ID 70039**

Wednesday, May 25, 2011 1:03:40 PM



Page 1

Item ID: D3371-041

Accept



Setup Start



Revision ID:

Item Name: Pedal Lock Assembly

Stop



Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/05/25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3371

Rev B

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.  
2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.  
3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5  
4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	<u>MU395L</u>

Batch

MU395L

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble lanyard to cyclic sock as per Dwg D3384  
Identify as D3384-045

SA 11/07/19GS 11/07/18 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70039**

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Page 2

Item ID: D3371-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Assembly

Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371. 2- Identify as D3371-041 & attach keys 3- Record the Key Number on page 4								
150		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
160		0.00							
	Identify as per dwg & Stock Location: <u>403</u>								
Packaging	Memo	0.00							
Packaging									

SB 11/07/19

8 11/07/19

43

11/7/19 sf 34

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 70039**

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Item ID: D3371-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Assembly

Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/19

MR

11-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 70039

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly






Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																									
238-028  3/16" Dowel Pin .5" long		Purchased	No			120	Each	238.0000	2	8																												
<table><tr><td></td><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td></td></tr><tr><td></td><td>ST399</td><td>238</td><td></td><td></td></tr><tr><td></td><td>106673</td><td>98</td><td></td><td></td></tr><tr><td></td><td>108114</td><td>99</td><td></td><td></td></tr><tr><td></td><td>17848</td><td>41</td><td></td><td></td></tr></table>															<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			ST399	238				106673	98				108114	99				17848	41		
	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																																			
	ST399	238																																				
	106673	98																																				
	108114	99																																				
	17848	41																																				
AN526C832R6  Screw		Purchased	No			120	Each	358.0000	4	16																												
<table><tr><td></td><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td></td></tr><tr><td></td><td>ST327</td><td>358</td><td></td><td></td></tr><tr><td></td><td>16612</td><td>358</td><td></td><td></td></tr></table>															<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			ST327	358				16612	358												
	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																																			
	ST327	358																																				
	16612	358																																				
D2728-7  Dart Logo label		Manufactured	No			120	Each	0.0000	0	0																												
<table><tr><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td>B 22 554</td><td></td><td></td></tr></table>																					B 22 554																	
		B 22 554																																				
D3371-1  Pedal Lock Base		Manufactured	No			120	Each	0.0000	1	4																												
<table><tr><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td><td></td><td></td></tr></table>																																						
D3371-3  Pedal Lock Cover		Manufactured	No			120	Each	3.0000	1	4																												
<table><tr><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td>B 69897</td><td></td><td></td></tr><tr><td></td><td></td><td>(4)</td><td></td><td></td></tr></table>																					B 69897					(4)												
		B 69897																																				
		(4)																																				

B 69897

(4)

B 70041

SB 11/07/19

SO 11/07/19

SB 11/07/19

SO 11/07/19

SO 11/07/19

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Page 2

Work Order ID: 70039

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

D3373-7 Manufactured No

120 Each 0.0000 1



Cam Lock

D3385-3 Manufactured No

120 Each 109.0000 1



Hinge

Location

Loc Qty

Loc Code

ST051

109

22387

109

CBL-1240 Purchased No

130 f 385.7460 1.6666



Cable

Location

Loc Qty

Loc Code

ST284

385.746

113565

85.746

116438

300

CBL-460 Purchased No

130 Each 82.0000 2



Loop Sleeve

Location

Loc Qty

Loc Code

ST284

82

116953

82

D3384-1 Manufactured No

130 Each 0.0000 1



Cyclic Sock

AN960-416 NAS1149F0463P Purchased No

140 Each 0.0000 2



Washer

Wednesday, May 25, 2011 1:03:37 PM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 70039



Parent Item: D3371-041



Parent Item Name: Pedal Lock Assembly

Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

HX-81

Purchased

No

140

Each

27.0000

1

4



1/4"-20 SHCS 3/8" long



SO 11/07/19

Location

Loc Qty

Loc Code

ST390

27

114383

27

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

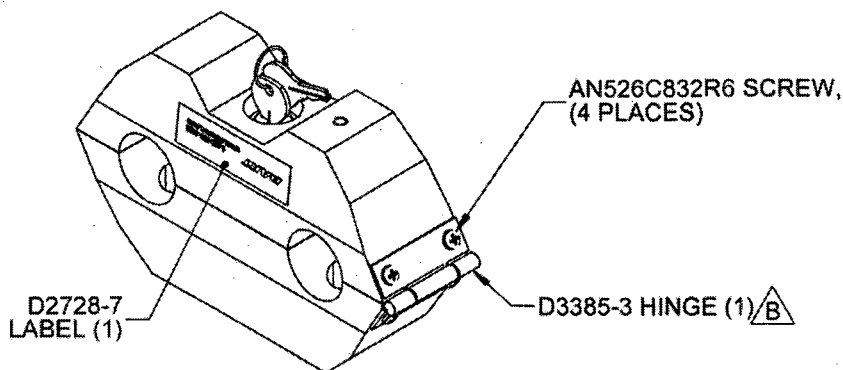
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

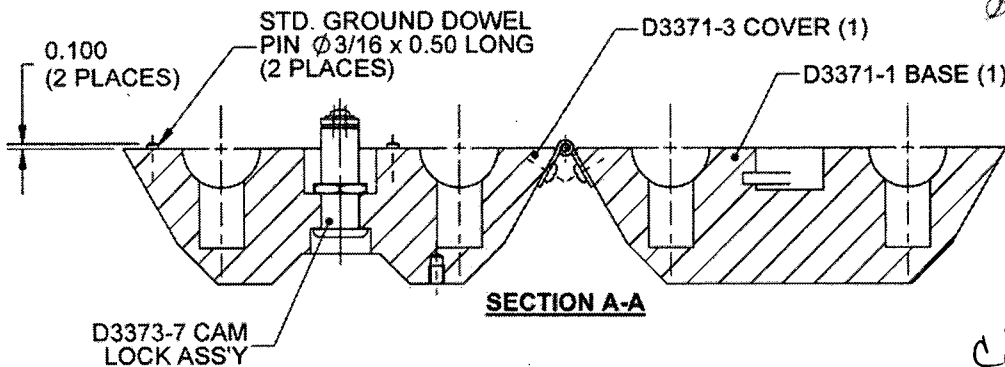


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

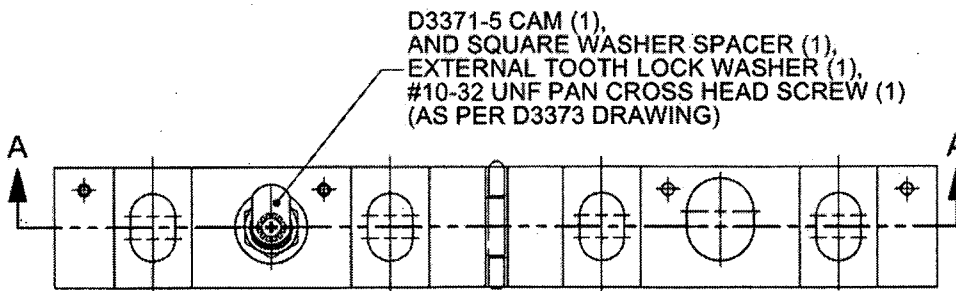


**PEDAL LOCK SHOWN LOCKED WITH KEY**

**RELEASED**  
*[Signature]*  
05/04/28



*CL 11/05/25*



### **D3371-051 PEDAL LOCK ASSEMBLY**

#### **NOTES:**

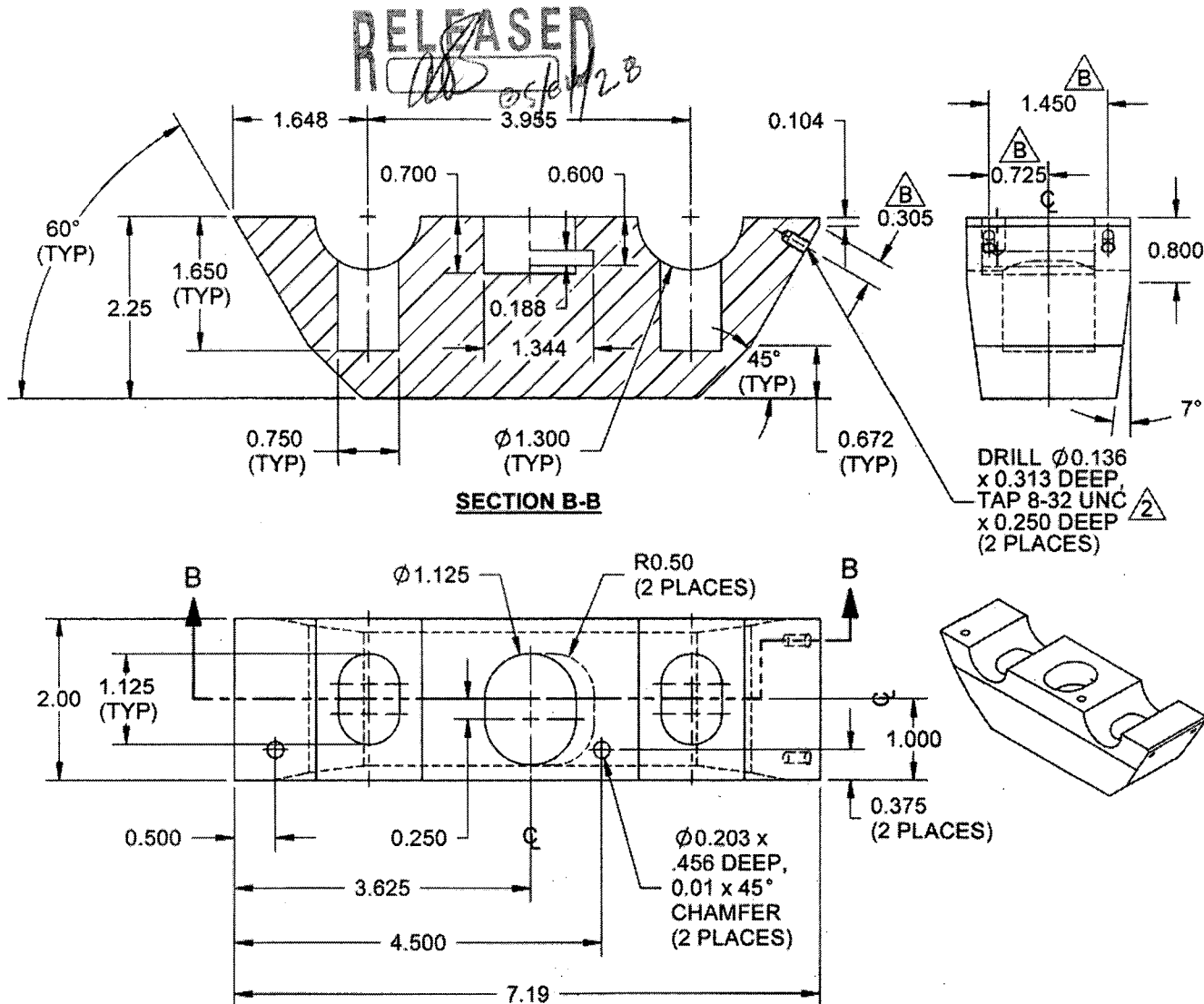
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3371</b>	REV. B SHEET 2 OF 4
DATE <b>05.03.22</b>	TITLE <b>PEDAL LOCK</b>		SCALE 1:2

**NOTES:**

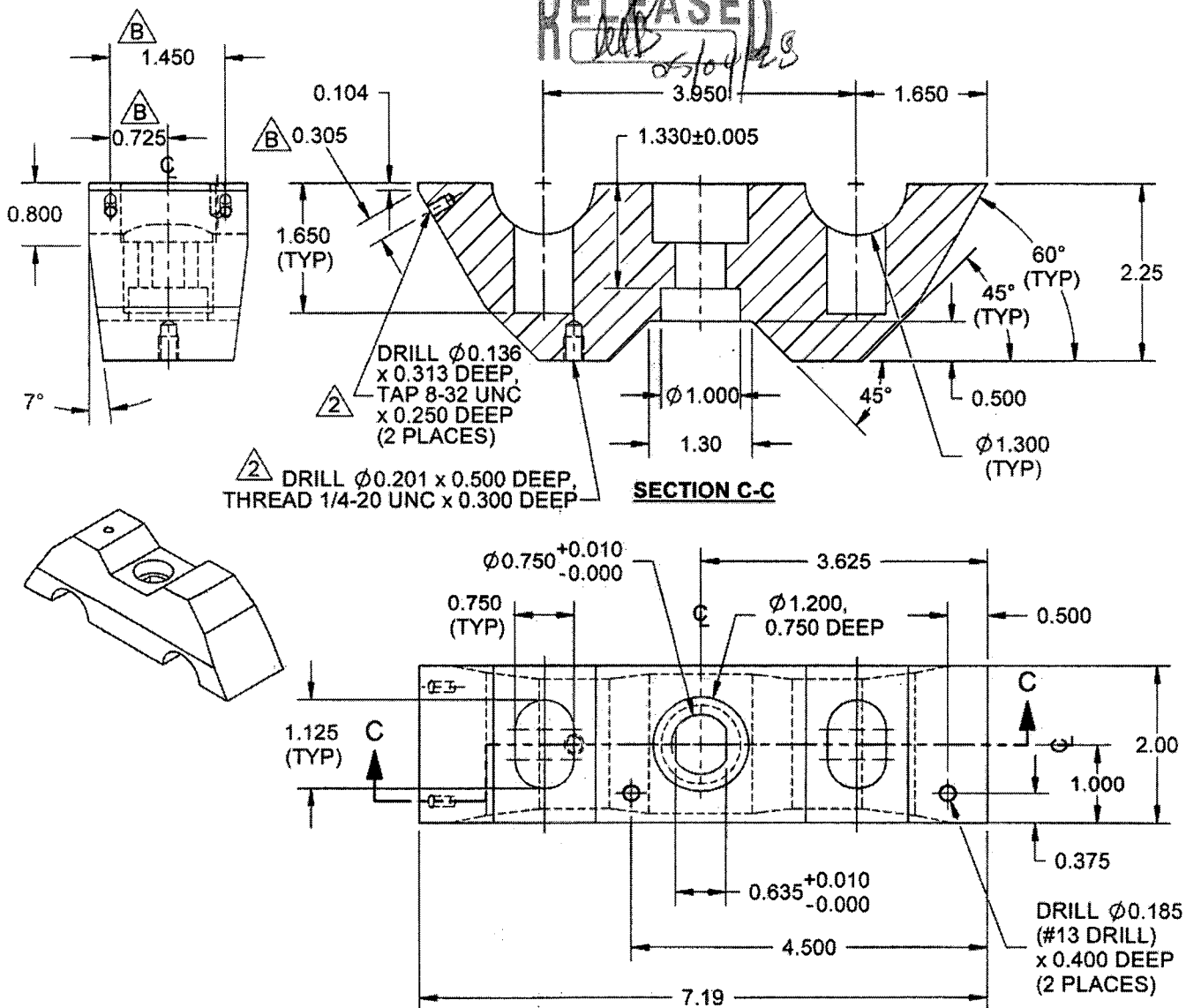
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3371</b>	REV. B SHEET 3 OF 4
DATE <b>05.03.22</b>	TITLE <b>PEDAL LOCK</b>		SCALE 1:2

**NOTES:**

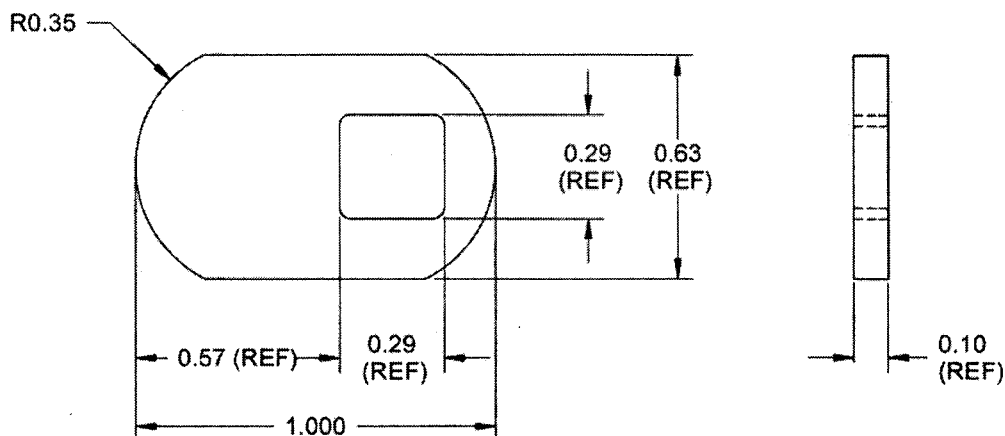
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3371</b>	REV. B SHEET 4 OF 4
DATE <b>05.03.22</b>	TITLE <b>PEDAL LOCK</b>		SCALE 2:1

**RELEASED**  
*[Signature]*  
05/04/20**SPECIFICATION CONTROL DRAWING****D3371-5 CAM****NOTES:**

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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